

23

Date: Wednesday, 5/16/2007 8:14:46 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 206/OH-58 SADDLE, INBOARD, RIGHT SIDE - UNDER
 Job Number : 32385 REVIEW
 Estimate Number : 10937
 P.O. Number : N/A Part Number : D29392 *up*
 This Issue : 5/16/2007 S.O. No. : N/A Drawing Number : D2939 REV C
 Prsht Rev. : NC Project Number : N/A
 First Issue : N/A Type : MACHINED PARTS Drawing Revision : C
 Previous Run : 30483 Material : N/A
 Due Date : 6/6/2007 Qty: 16 Um: Each
 Written By :
 Checked & Approved By : *J.F. 07.05.16*
 Comment : Est: B 00.06.26 New DWG rev (mpp 2069) EC
 Est Rev: C As per Rev C 07-03-19 JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D6101001 7075-T7351 2X6X6.25



Comment: Qty.: 1.0000 Each(s)/Unit Total : 16.0000 Each(s)

Issue material from stock: 7075-T7351 (QQ-A-250/12)

Cut Size 2.0" x 6.25" X 6.00" Grain Along 6.00" Length

Batch No: *B25345 J.F. 07/05/24*

2.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

Program part number and batch number.

1-Inspect part number and batch number are programmed correctly.

2-Machine Step No 1 of Folio and visually inspect as per dwg D2939 & attached Dimension Sheet

3-Machine Step No 2 of Folio and visually inspect as per dwg D2939 & attached Dimension Sheet

4-Machine Step No 3 of Folio and visually inspect as per dwg D2939 & attached Dimension Sheet

5-Deburr

J.F. 07/05/25 J.L. 07/05/27 (16)

3.0 MILLING CONV. CONVENTIONAL MILLING MACHINE



Comment: CONVENTIONAL MILLING MACHINE

Machine Keyway and inspect per attached dimension sheet

Er 07/06/07 (16)

4.0 QC1 INSPECT ALL DIM TO DIM SHEET



Comment: INSPECT ALL DIM TO DIM SHEET

J.F./Er 07/06/07 (16)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ _____ Date: 07/07/11
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
		1 saddle is scrap because the length between the end mill and the holder was not long enough, so the holder went in the piece.	<i>JF</i>	Scrap and replace Destroy re-adjust the tool length.	<i>JF</i> 07/05/25	<i>JF</i> 07/05/25	<i>JF</i> 07/05/25	<i>JF</i> 07/05/25

NOTE: Date & initial all entries

Date: Wednesday, 5/16/2007 8:14:46 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206/OH-58 SADDLE, INBOARD, RIGHT SIDE - UNDER
REVIEW

Job Number: 32385

Part Number: D29392

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

mk 07/06/09 16

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

HA 07-06-11 16

7.0

SPRAY PAINTING

SPRAY PAINTING



Comment: SPRAY PAINTING

-PRIME

-PAINT DELFLEET BLUE (PER QSI005)

-CLEAR DELFLEET

N/A

8.0

QC14

INSPECT SPRAY PAINT



Comment: INSPECT SPRAY PAINT

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *54445*

stock unpacked!

07/17/9 UP (12)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

(12) 07/07/11

Job Completion



(change to 'UP' in Accept)

U 07/07/11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
07-06-15	7	split to send 1 to outside supplier for painting	U	07-06-15	1	U	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	32385
Description: 206 Saddle, Inboard, Right side	Part Number:	D2939-2
Inspection Dwg: D2939 Rev. C		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2939 Rev. C and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		.116"	.116"	.114	.116		
B	0.100	0.140		.114"	.114"	.113	.115		
C	0.100	0.140		.117"	.117"	.117	.115		
D	0.210	0.230		.222"	.222"	.219	.219		
E	1.245	1.255		1.250"	1.250"	1.250	1.250		
F	1.245	1.255		1.250"	1.250"	1.250	1.250		
G	2.495	2.505		2.502"	2.501"	2.500	2.500		
H	0.510	0.515		0.511	0.511	0.511	0.511		
I	1.572	1.582		1.580"	1.580"	1.577	1.577		
J	2.495	2.505		2.500"	2.500"	2.500	2.500		
K	0.257	0.262		Ø.257"	Ø.257"	Ø.257"	Ø.257"		
L	0.312	0.317		Ø.312"	Ø.312"	Ø.312"	Ø.312"		
M	0.235	0.240		0.239	0.239	0.239	0.239		
N	0.100	0.140		.120"	.120"	.118	.118		
O	0.540	0.560		.550"	.552"	.551	.550		
P	0.490	0.510		.503"	.503"	.501	.498		
Q	3.715	3.725		3.721"	3.721"	3.720	3.720		
R	2.720	2.760		2.745"	2.745"	2.745	2.745		
S	0.240	0.270		.253"	.253"	.248	.250		
T	0.100	0.180		.140"	.140"	.140"	.140"		
U	1.625	1.635		1.630"	1.630"	1.630	1.630		
V	1.362	1.372		1.368"	1.368"	1.367	1.367		
W	0.316	0.321		Ø.318"	Ø.318"	Ø.318	Ø.318		
X	1.250	1.270		1.260"	1.259"	1.259"	1.260"		
Y	1.565	1.585	DT8695 A/B	1.575	1.575"	1.575"	1.575"		
Z	0.178	0.198		R.188"	R.188"	R.188"	R.188"		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by: <u>J.F. / J.L.</u>	Audited by: <u>gml</u>
Date: <u>07/05/25 / 07/05/26 / 07/06/07</u>	Date: <u>07/06/07</u>

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	

DART AEROSPACE LTD	Work Order:	32385
Description: 206 Saddle, Inboard, Right side	Part Number:	D2939-2
Inspection Dwg: D2939 Rev. C		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2939 Rev. C and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		.115	.115	.118	.115		
B	0.100	0.140		.115	.115	.116	.115		
C	0.100	0.140		.118	.121	.120	.116		
D	0.210	0.230		.219	.218	.219	.219		
E	1.245	1.255		1.250	1.250	1.250	1.256		
F	1.245	1.255		1.250	1.250	1.250	1.250		
G	2.495	2.505		2.500	2.500	2.500	2.500		
H	0.510	0.515		0.511	0.511	0.511	0.514		
I	1.572	1.582		1.577	1.577	1.577	1.577		
J	2.495	2.505		2.500	2.500	2.500	2.500		
K	0.257	0.262		.259	.259	.259	.259		
L	0.312	0.317		.315	.315	.315	.315		
M	0.235	0.240		0.239	.239	.239	.239		
N	0.100	0.140		.117	.117	.116	.119		
O	0.540	0.560		.550	.550	.551	.549		
P	0.490	0.510		.501	.501	.500	.498		
Q	3.715	3.725		3.719	3.720	3.720	3.720		
R	2.720	2.760		2.745	2.745	2.745	2.745		
S	0.240	0.270		.250	.250	.249	.249		
T	0.100	0.180		.140	.140	.140	.140		
U	1.625	1.635		1.630	1.630	1.630	1.630		
V	1.362	1.372		1.367	1.367	1.367	1.367		
W	0.316	0.321		.320	.320	.320	.320		
X	1.250	1.270		1.260	1.258	1.260	1.262		
Y	1.565	1.585	DT8695 A/B	1.575	1.575	1.575	1.576		
Z	0.178	0.198		.188	.188	.188	.188		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by: **J.L.**
Date: **07/05/26 / 07/06/07**

Audited by: **J.M.**
Date: **07/06/09**

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	

DART AEROSPACE LTD	Work Order:	32385
Description: 206 Saddle, Inboard, Right side	Part Number:	D2939-2
Inspection Dwg: D2939 Rev. C		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2939 Rev. C and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.100	0.140		.119	.118	.118	.118		
B	0.100	0.140		.119	.117	.117	.118		
C	0.100	0.140		.120	.120	.120	.120		
D	0.210	0.230		.218	.219	.220	.218		
E	1.245	1.255		1.250	1.256	1.249	1.250		
F	1.245	1.255		1.250	1.250	1.250	1.250		
G	2.495	2.505		2.500	2.500	2.500	2.500		
H	0.510	0.515		0.511	0.511	0.511	0.511		
I	1.572	1.582		1.577	1.577	1.577	1.577		
J	2.495	2.505		2.500	2.499	2.500	2.499		
K	0.257	0.262		.259	.259	.259	.259		
L	0.312	0.317		.315	.315	.315	.315		
M	0.235	0.240		.239	.239	.239	.239		
N	0.100	0.140		.119	.119	.119	.117		
O	0.540	0.560		.550	.551	.551	.550		
P	0.490	0.510		.501	.501	.502	.501		
Q	3.715	3.725		3.719	3.719	3.720	3.720		
R	2.720	2.760		2.745	2.745	2.745	2.745		
S	0.240	0.270		.249	.248	.250	.248		
T	0.100	0.180		.140	.140	.140	.140		
U	1.625	1.635		1.630	1.636	1.630	1.630		
V	1.362	1.372		1.367	1.367	1.367	1.367		
W	0.316	0.321		.320	.320	.320	.320		
X	1.250	1.270		1.262	1.261	1.260	1.261		
Y	1.565	1.585	DT8695 A/B	1.576	1.576	1.575	1.575		
Z	0.178	0.198		.188	.188	.188	.188		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by: SL	Audited by: ml
Date: 07/05/26 / 07/06/07	Date: 07/06/09

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	

DART AEROSPACE LTD	Work Order:	32385
Description: 206 Saddle, Inboard, Right side	Part Number:	D2939-2
Inspection Dwg: D2939 Rev. C		Page 1 of 1

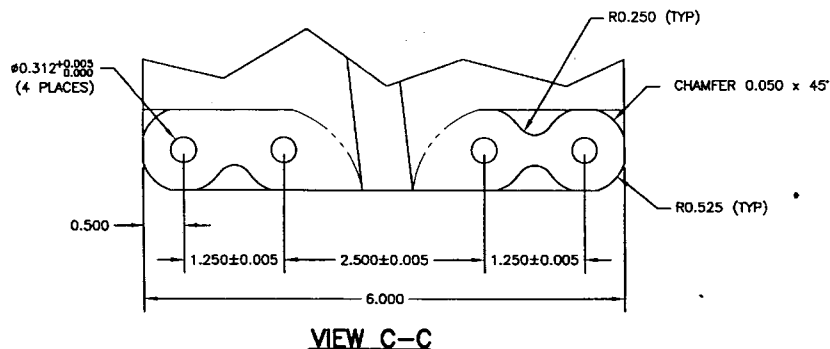
Inspect dimensions highlighted on inspection sheet drawing D2939 Rev. C and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.100	0.140		.119	.126	.120	.120		
B	0.100	0.140		.119	.120	.119	.120		
C	0.100	0.140		.120	.118	.120	.120		
D	0.210	0.230		.219	.219	.220	.219		
E	1.245	1.255		1.250	1.250	1.250	1.250		
F	1.245	1.255		1.250	1.250	1.249	1.250		
G	2.495	2.505		2.500	2.500	2.500	2.500		
H	0.510	0.515		0.511	0.511	0.511	0.511		
I	1.572	1.582		1.574	1.574	1.574	1.574		
J	2.495	2.505		2.500	2.500	2.500	2.500		
K	0.257	0.262		.259	.259	.259	.259		
L	0.312	0.317		.315	.315	.315	.315		
M	0.235	0.240		.239	.239	.239	.239		
N	0.100	0.140		.118	.118	.119	.120		
O	0.540	0.560		.549	.550	.548	.548		
P	0.490	0.510		.502	.500	.501	.500		
Q	3.715	3.725		3.719	3.720	3.720	3.720		
R	2.720	2.760		2.745	2.745	2.745	2.745		
S	0.240	0.270		.250	.250	.249	.249		
T	0.100	0.180		.140	.140	.140	.140		
U	1.625	1.635		1.630	1.630	1.630	1.630		
V	1.362	1.372		1.367	1.367	1.367	1.367		
W	0.316	0.321		.320	.320	.320	.320		
X	1.250	1.270		1.261	1.260	1.260	1.262		
Y	1.565	1.585	DT8695 A/B	1.545	1.545	1.545	1.546		
Z	0.178	0.198		.188	.188	.188	.188		
AA									
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AG									
AH									
Accept/Reject									

Measured by: J.L.
Date: 07/05/27 / 07/06/07

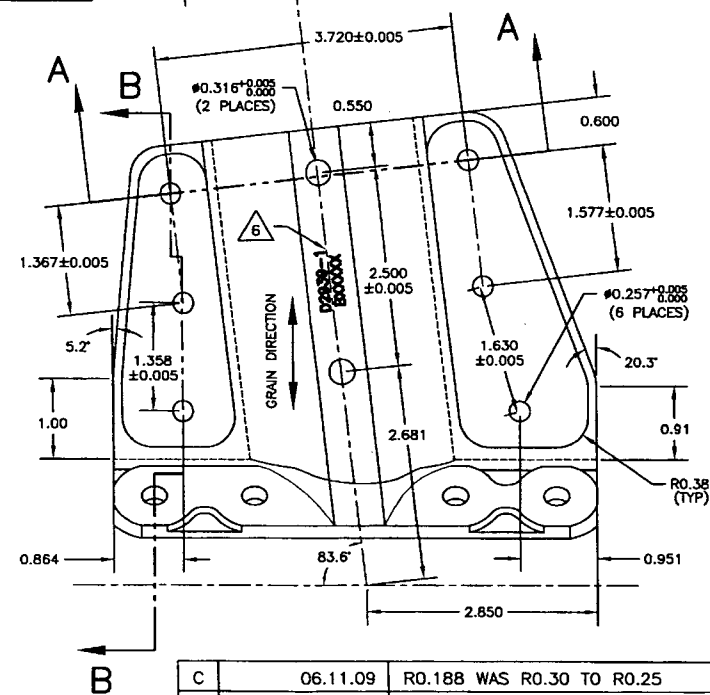
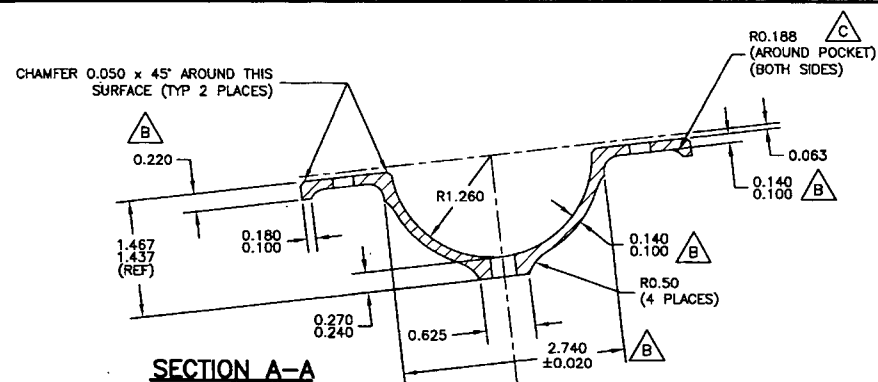
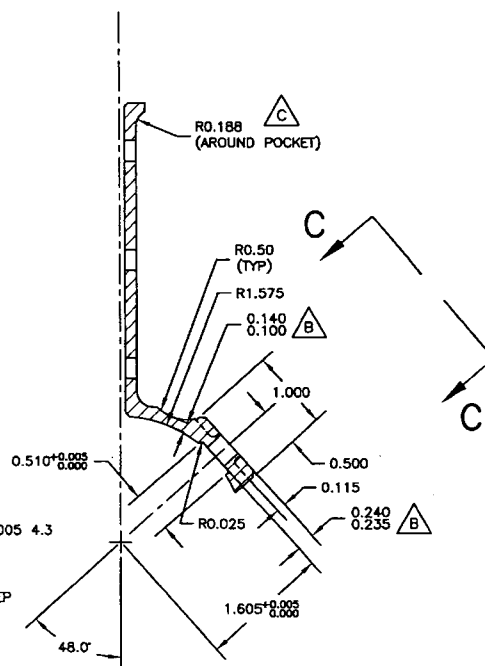
Audited by: [Signature]
Date: 07/06/09

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	[Signature]



D2939-1 LH SADDLE (SHOWN)
D2939-2 RH SADDLE (OPPOSITE)

- NOTES:**
- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)
 (MAKE FROM D6101-001 SADDLE BILLET, 7075)
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
 - 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
 - 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 5) ALL DIMENSIONS ARE INCHES
 - 6) ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP



C	06.11.09	R0.188 WAS R0.30 TO R0.25
B	00.05.29	CHANGED DEOMETRY AND MATERIAL
A	99.11.12	NEW ISSUE
DESIGN	4	DRAWN BY CB
CHECKED	PH	APPROVED
DATE	06.11.09	TITLE
		SADDLE INSIDE
		DART DART AEROSPACE USA, INC.
		REV. C
		SHEET 1 OF 1
		SCALE
		2:3

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07.02.12 #